

Work Order ID 158280

Friday, March 17, 2017 8:20:27 AM

158280

Page 1

Item ID: D412-698-032

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Door Roller RH Composite Door

Start Date: 3/27/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan:  Date: MAR 17 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-032		CHG002						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

MAR 16 2017

DAS
21
9-89

1703-17 (2)

MAR 27 2017

DAS
28
9-89

MAR 16 2017

DAS
27
9-89

MAR 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

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158280

Page 2

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Start Date: 3/27/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/29/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-698-032 Location :FG034	0.00 0.00					DAS 28 27 9-89 9-89		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					DAS 21 9-89	MAR 22 2017	

MAR 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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		OTHER : ☐																																																																					

Picklist Print

Friday, March 17, 2017 8:20:36 AM

Page 1

Work Order ID: 158280

158280

Parent Item: D412-698-032

D412-698-032

Parent Item Name: Cabin Door Roller RH Composite Door

Start Date: 3/27/2017

Required Date: 3/29/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08.07.03 EC verified by:LL
16.07.28 IIN REV.F DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-144 *D3121-144* Bracket Assembly		Manufactured	No			110	Each	0.0000	1	1			
D3202-3 *D3202-3* Cover		Manufactured	No			110	Each	9.0000	1	1			
DAS 27 9-89 Location ST195a 148198 148300 Loc Qty 9 1 8 Loc Code													
D3674-041 *D3674-041* Roller Bracket Assembly		Manufactured	No			110	Each	39.0000	3	3			
DAS 27 9-89 Location ST050 143720 Loc Qty 39 39 Loc Code													
D3674-044 *D3674-044* Roller Bracket Assembly		Manufactured	No			110	Each	4.0000	1	1			
DAS 27 9-89 Location ST050 149770 150039 Loc Qty 4 2 2 Loc Code													

2

MAR 22 2017

DAS 28 9-89

MAR 16 2017

MAR 16 2017

MAR 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Friday, March 17, 2017 8:20:36 AM

Page 2

Work Order ID: 158280

158280

Parent Item: D412-698-032

D412-698-032

Parent Item Name: Cabin Door Roller RH Composite Door

Start Date: 3/27/2017

Required Date: 3/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3674-045

Manufactured No

110 Each

4.0000

1

1

DAS
6
9-89

MAR 16 2017

D3674-045

Roller Bracket Assembly

**

Location

Loc Qty

Loc Code

ST050

4

150040

4

D3675-1

Manufactured No

110 Each

31.0000

9

9

DAS
6
9-89

MAR 16 2017

D3675-1

Sliding Door Bracket

**

Location

Loc Qty

Loc Code

ST051

31

148408

11

149599

20

DAS
27
9-89

27
7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 158280***158280***

Page 1

Friday, March 17, 2017 9:55:48 AM

Item ID: D412-698-032

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller RH Composite Door

Start Date: 3/27/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	F

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-032 CHG002

DAS
21
9-89

MAR 17 2017

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
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8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Qty -037	Qty -038	Part Number	Description
X								D412-698-019	BEARING OVERHAUL KIT
	X							D412-698-021	REPLACEMENT SHIM KIT
		X						D412-698-031	CABIN DOOR ROLLER KIT, LH
			X					D412-698-032	CABIN DOOR ROLLER KIT, RH
				X				D412-698-033	REPLACEMENT DOOR TRACK KIT
					X			D412-698-035	DOOR HANDLE KIT
						X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
							X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
7								D3121-21	BOLT
5								D3121-241	BEARING ASSEMBLY
1								D3137-3	GUIDE
1								D3137-5	WASHER
2								D3183-045	BEARING ASSEMBLY
	3							D3238-1	SHIM
	1							D3238-3	SHIM
	2							D3238-5	SHIM
	6							D3238-11	SHIM
	2							D3238-13	SHIM
	4							D3238-15	SHIM
		1						D3121-143	BRACKET ASSEMBLY
			1					D3121-144	BRACKET ASSEMBLY
		1	1	1				D3202-3	COVER
		3	3					D3674-041	BRACKET ASSEMBLY
		1						D3674-043	ROLLER BRACKET ASSEMBLY
			1					D3674-044	ROLLER BRACKET ASSEMBLY
		1	1					D3674-045	ROLLER BRACKET ASSEMBLY
		9	9	9				D3675-1	BRACKET
						1		D3675-5	FORWARD BRACKET, LH
							1	D3675-6	FORWARD BRACKET, LH
					2			D3779-041	HANDLE ASSEMBLY
					2			D3779-3	PLATE
					2			D3779-043	HANDLE ASSEMBLY
					12			AN525-832R8	SCREW
					12			NAS1149D0332J	WASHER (AN960JD10L)
					12			MS21042L3	NUT
					12			MS24694-S51	SCREW
1								MS24694-S101	SCREW